

Date: Monday, 3/6/2006 1:45:44 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 BEARPAW
 Job Number : 26051A
 Estimate Number : 10100
 P.O. Number : N/A
 This Issue : 3/6/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : N/A
 Written By : SEE JA COMMENT BELOW
 Checked & Approved By : JA 06.03.06
 Comment : Est Rev: C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM

Part Number : D30751
 Drawing Number : D3075 REV A2
 Project Number : N/A
 Drawing Revision : A2
 Material : N/A
 Due Date : 3/20/2006 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 1.8949 sf(s)/Unit Total : 37.8980 sf(s)

Pick:

blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12

Material: Black UHMW 1"(MUHMWB10)

Batch: 4100417/11066

M101254 / 29 PCS

J.F. 06/06/14

06/03/29

40

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

3-Deburr

J.F. 06/06/14

40

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/14

40

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L. 06/06/16

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:45:44 PM
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Process Sheet

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Drawing Name: R44 BEARPAW

Job Number: 26051A

Part Number: D30751

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

P 6/6/20

FA 0044 662-011

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

40
D 06/06/22

Job Completion



U 26-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 26051A
Description: R44 Bearpaw		Part Number: D3075-1
Inspection Dwg: D3075	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.070"	✓			
B	0.63	+/-0.030	.627"	✓			
C	0.250	+/-0.010	.252"	✓			
D	0.950	+0.030/-0.010	.948"	✓			
E	5.50	+/-0.030	5.499"	✓			
F	0.25 x 45°	+/-0.030	.280" x 45°	✓			
G	0.900	+/-0.010	.891"	✓			
H	0.375	+/-0.010	0.379"	✓			
I	1.30	+/-0.030	1.300"	✓			
J	5.70	+/-0.030	5.693"	✓			
K	0.37	+/-0.030	.379"	✓			
L	3.600	+/-0.010	3.603"	✓			
M	0.260	+0.005/-0.000	.260"	✓			
N	0.93	+/-0.030	.930"	✓			
O	0.30	+0.030/-0.000	.319"	✓			
P	1.08	+/-0.030	1.080"	✓			
Q	5.870	+/-0.010	5.872"	✓			
R	10.14	+/-0.030	10.144"	✓			

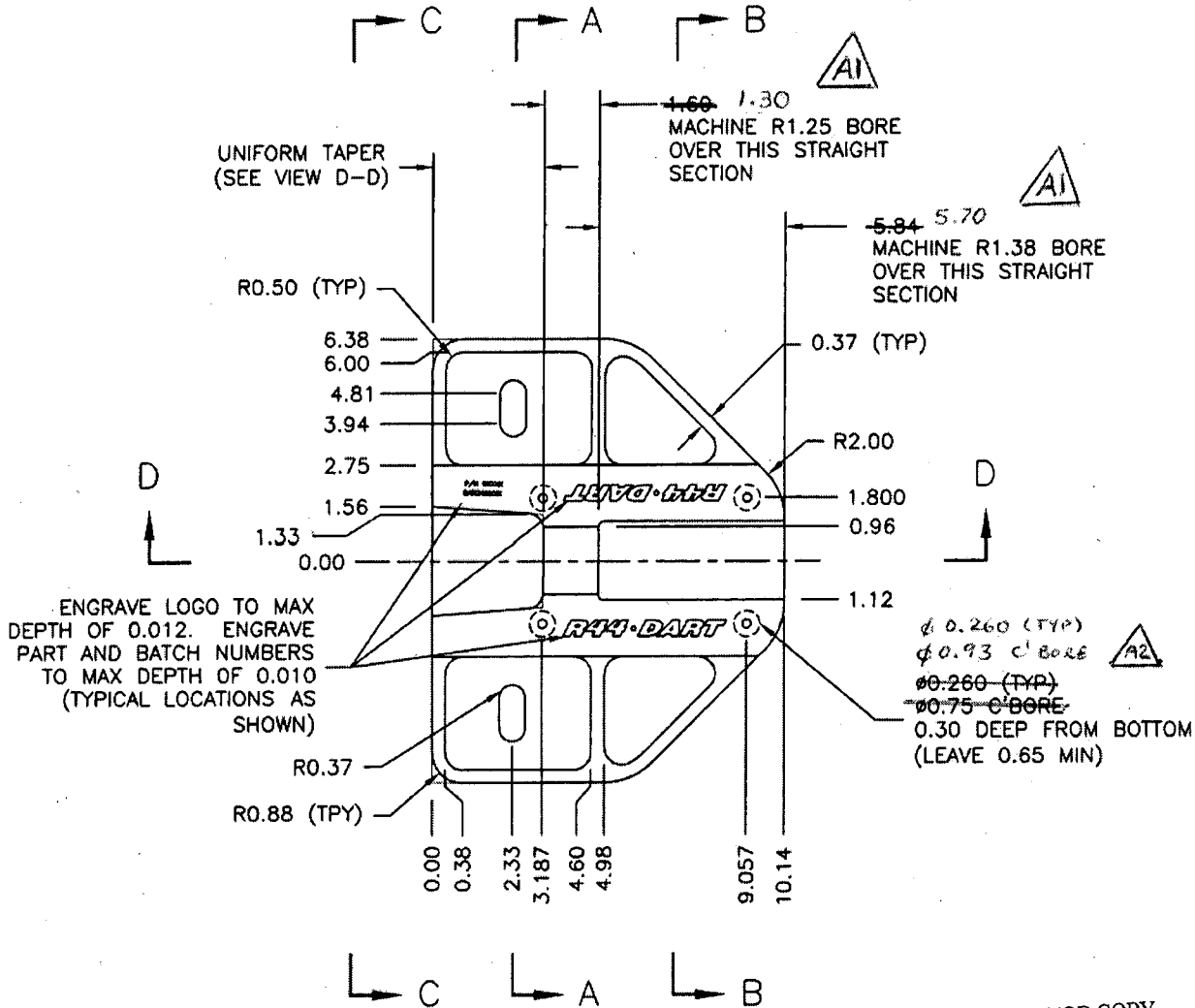
Measured by: J.F.	Audited by: ES	Prototype Approval:	N/A
Date: 06/06/14	Date: 06/06/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3075	REV. A SHEET 1 OF 2
DATE 02.01.04	TITLE R44 BEARPAW		SCALE 1:5
A	02.01.04	NEW ISSUE	
A1	RF 02.02.01	1.30 WAS 1.60 ; 5.70 WAS 5.84	
A2	RF 03.01.06	ϕ 0.93 WAS ϕ 0.75	

RELEASED
02.01.10 *[Signature]*



D3075-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. **26051A**

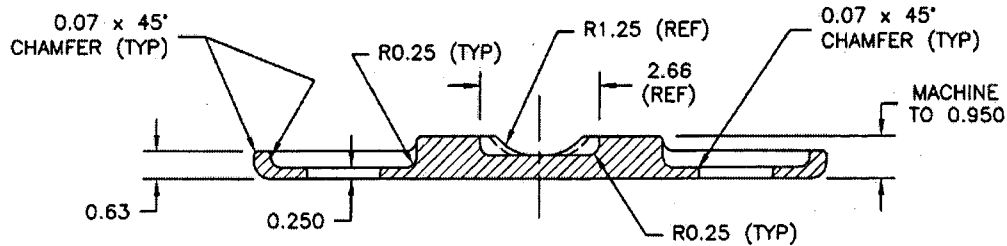
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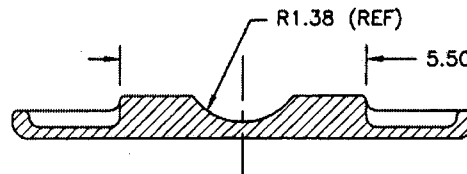
DART

DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3075	REV. A SHEET 2 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:4

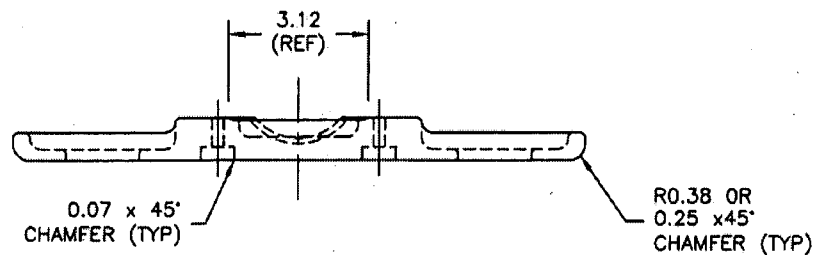
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02.01.10



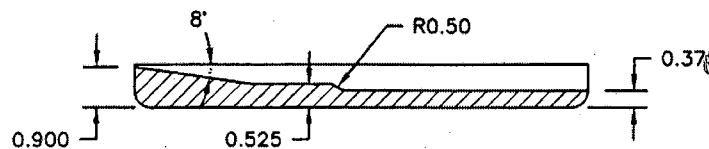
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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